

**What is claimed:**

1. Method of making an industrial fabric by using laminated object manufacture.
2. Method according to claim 1,  
5 characterized in  
that the method comprising the steps of laminating a series of  
layers of film material and cutting perforations in the films of the  
laminate to provide a foraminous fabric.
3. Method according to claim 1 or 2,  
10 characterized in  
that the film layer is bonded to the previous layer by application of  
pressure, preferably by passing the two components through a  
bonding nip.
4. Method according to one of the preceding claims,  
15 characterized in  
that adhesive having been applied to the underside of the most  
recent layer to be laid down.
5. Method according to one of the preceding claims,  
characterized in  
20 that the step of cutting perforations is performed using laser light.
6. Method according to one of the preceding claims,  
characterized in  
that the method involving the step of cutting perforations in at least  
one of said film layers after the film layer is secured to another film

layer or film layers, wherein one of said another layer or layers having pre-cut perforations therein.

7. Method according to one of the preceding claims,  
characterized in  
5 that the cut-out waste is removed by the following means alone or in combination: directing a burst of air at the waste material via a high pressure air jet or by using an air knife or sucking the waste by vacuum.
8. Method according to claim 7,  
10 characterized in  
that the method further comprise the step of permanently bonding the layers by applying pressure load after removal of said cut-out waste.
9. Method according to one of the preceding claims,  
15 characterized in  
that in a cut-out step one or individual laid down films are perforated.
10. Method according to one of the preceding claims,  
20 characterized in  
that the method further comprises the steps of starting with the largest holes in the first layer and then work up with subsequent layers possessing smaller holes.
11. Method according to one of the preceding claims,  
25 characterized in  
that the perforations are cut-out in such a way that the aperture size, shape and/or distribution varies deliberately and / or is

randomised throughout the fabric wherein the porosity of the fabric is kept substantially uniform.

12. Method according to one of the preceding claims,  
characterized in  
5 that the manufacture of the fabric is stopped at a semi-complete stage.
13. Method according to claim 12,  
characterized in  
10 that a further blank film layer is bonded to the laminated structure generating a semi-complete work piece, and that said semi-complete work piece is stored in roll form for further processing by cutting the blank film layer and the addition of a further set of individually cut laminate which can form the opposite face of the fabric to the wearside.
- 15 14. Method according to claim 13,  
characterized in  
that a reference point is included to said semi-complete work piece for precise location of the laser beam with respect to said work piece.
- 20 15. Method according to one of the preceding claims,  
characterized in  
that the manufacturing includes the step of spiral winding the first formed laminate over rollers and bonding the laminated fabric to a return of the spiral.
- 25 16. Method according to one of the claims 1 to 14,  
characterized in

that the film layers are located side by side and the film layers of the subsequent layer may straddle the joints between the films in the first layer.

5 17. Industrial fabric manufactured with a method according to one of the claims 1 to 16.

18. Industrial fabric according to claim 17,  
characterized in  
that the orifices of the paperside apertures are smaller than at the  
wearside.

10 19. Industrial fabric according to claim 17 or 18,  
characterized in  
that the thickness of the various film layers being laminated  
together are different, preferably that the thickness of the layers  
towards the intended machine side is thicker than the ones towards  
15 the intended paper side.

20. Seamed industrial fabric comprising a laminate of foraminous films,  
wherein seam loops are defined by film material.

21. Seamed industrial fabric according to claim 20,  
characterized in  
20 that said seam loops being provided by folding a fabric structure to  
provide a double thickness fabric having seam loops.

22. Seamed industrial fabric according to 20 or 21,  
characterized in  
that said seam loops being provided by encircling film material

around a fabric inner so as to define loops between said encircling film and said inner.

23. Industrial fabric or seamed industrial fabric according to one of the claims 17 to 22,  
5 characterized in  
that said fabric is a paper machine clothing, preferably a dryer fabric.

24. Industrial fabric or seamed industrial fabric according to one of the claims 17 to 23,  
10 characterized in  
that said film material comprises any of the following materials either alone or in combination: polyester, polyimide or PEN (polyethylenenaphalate), preferably high performance films, such as MYLAR (trade mark of DuPont), KAPTON (trade mark of DuPont)  
15 or TEONEX (trade mark of DuPont).

25. Industrial fabric or seamed industrial fabric according to one of the claims 17 to 24,  
characterized in  
that the individual film materials used for the individual layers of the  
20 fabric may be the same or different.

26. Industrial fabric or seamed industrial fabric according to one of the claims 17 to 25,  
characterized in  
that the film may comprise nonwoven sheets made from fibres.

25 27. Industrial fabric or seamed industrial fabric according to one of the claims 17 to 26,

characterized in  
that the adhesive material for bonding adjacent film layers comprise  
any of the following materials either alone or in combination:  
epoxies, epoxy bismaleimides, silicone RTV's.

- 5        28. Industrial fabric or seamed industrial fabric according to one of the  
         claims 17 to 27,  
         characterized in  
         that said fabric comprise an array of yarns extending in the intended  
         running direction of said fabric.
- 10       29. Industrial fabric or seamed industrial fabric according to one of the  
         claims 17 to 28,  
         characterized in  
         that said yarns are monofilaments or multifilaments and preferably  
         made from any of the following materials: steel, polyester,  
15       polyamide, polyolefin, PPS, PEEK para-aramid or from inorganic  
         material, for example glass or basalt.
30. Industrial fabric or seamed industrial fabric according to one of the  
         claims 17 to 29,  
         characterized in  
20       that said yarns are at least partly, and preferably fully, encapsulated  
         in machine direction lands of said fabric.
31. Industrial fabric or seamed industrial fabric according to claim 30,  
         characterized in  
         that said yarns have been incorporated into the fabric structure,  
25       after having initially laid down a number of layers.

32. Industrial fabric or seamed industrial fabric according to claim 30 or 31,  
characterized in  
that at the position in the Z direction where said yarns are to be  
5 included a next film layer have been laid down as strips orientated  
in the running direction with small gaps between them to  
accommodate the yarns.
33. Industrial fabric or seamed industrial fabric according to one of the  
claims 30 to 32,  
10 characterized in  
that the film thickness will correspond to the yarn diameter.
34. Industrial fabric or seamed industrial fabric according to one of the  
claims 30 to 33,  
characterized in  
15 that void not filled by the yarn is filled with a polymer to secure the  
yam to the structure.